Work Order ID 73196

Friday, August 26, 2011 7:16:30 AM

Item ID: D2734 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Step End Plate

Start Date: 8/26/2011 **Start Qty:** 40.00 **Cust Item ID:**

Required Date: 9/16/2011 **Req'd Qty:** 40.00 **Customer:**

Reference:

Approvals: **Process Plan:** CL **Date:** 11/08/26 **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Draw Nbr	Revision Nbr
D2734	Rev C

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100	FLOW WATER JET	0.00							
Waterjet	**Memo**	0.00				B11-8-30			
FLOW CNC Waterjet	1-Cut as per Dwg D 2734								
5052.063	Dwg Rev: C								
	Prog Rev: C								
	2-Deburr if necessary								
						45			
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	**Memo**	0.00				FB 11-8-30			
Quality Control									
120	QC8- Inspect parts - second check	0.00				counter			
QC	**Memo**	0.00				x45			
Quality Control									

8 6 of 31

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Small Fab Small Fab	Small Fab **Memo** Form as per drawing D2734	0.00 0.00				45			
140 QC Quality Control	QC5- Inspect part completeness to step on W/O **Memo**	0.00 0.00				county 45			
150 Packaging Packaging	Identify as per dwg & Stock Location: WA **Memo** *** STOCK IN STEP CELL***	0.00 0.00				45			

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W/O:		WORK ORDER CHANGES					
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

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Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00					11/9/06		
QC	**Memo**	0.00							
Quality Control									

MF
11-09-06

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

Friday, August 26, 2011 7:16:27 AM

Work Order ID: 73196

Parent Item: D2734

Parent Item Name: Step End Plate

Start Date: 8/26/2011 **Required Date:** 9/16/2011

Start Qty: 40.00 **Required Qty:** 40.00

Comments: IPP: □D□01.06.08□Removed Deburr□EC□□
IPP Rev:E 07-12-18 RevC as per dwg ECN1048 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M5052H32S.063		Purchased	No			100	sf	80.5000	0.0625	2.631579	3, HB 11-8-30		
5052-H32 .063 Sheet													

Location	Loc Qty	Loc Code
MAT022	80.5	
114322	80.5	

45

(14322)

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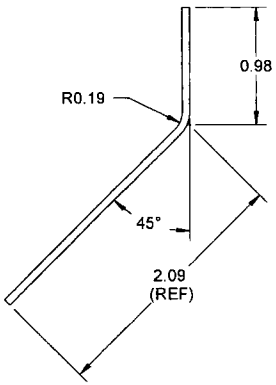
W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

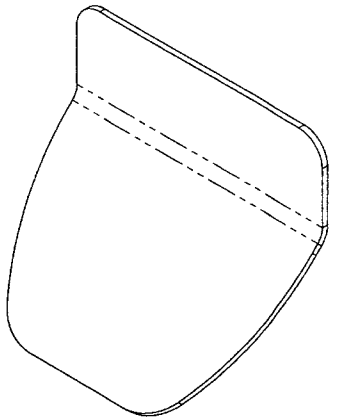
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

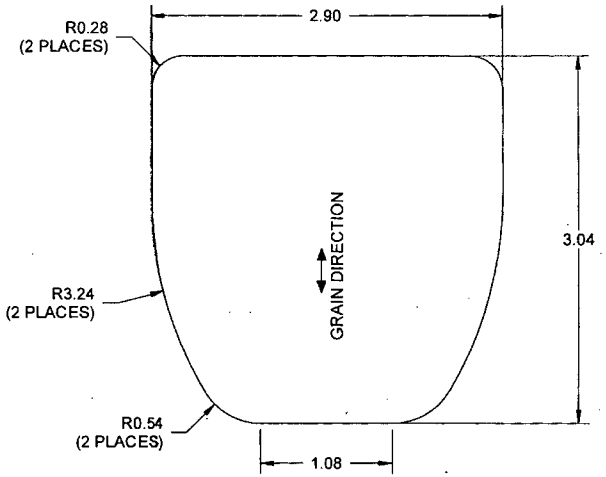
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries



D2734 END PLATE





D2734 FLAT PATTERN

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 73196

CL1110 8126

RELEASED
07.12.18 WD

NOTES:
1) MATERIAL: 5052-H32 ALUMINUM SHEET
PER AMS-QQ-A-250/8 OR AMS 4016
(REF. DART SPEC. M5052H32S.063) OR
6061-T6 (OR 6061-T6) ALUMINUM SHEET
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.063)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.05 lbs

REV.	DESCRIPTION	BY	DATE
C	ADD GRAIN DIRECTION NOTE; REDRAWN IN SOLIDWORKS	DC	07.11.20
B	0.976 WAS 1.016, 2.097 WAS 2.137	KE	98.10.05
A	NEW ISSUE	KE	97.12.10

DESIGN	KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	DC	
CHECKED		DRAWING NO. D2734 REV. C
MFG. APPR.		SHEET 1 OF 1
APPROVED		TITLE END PLATE SCALE 1:1
DE APPR.		
DATE	07.11.20	

DART AEROSPACE LTD	Work Order:	73196
Description: End Plate	Part Number:	D2734
Inspection Dwg: D2734 **Rev:** C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.90	+/-0.030	2.900	✓		V IB 02	
3.04	+/-0.030	3.039	✓		V	
0.063	+/-0.010	.063	✓		V	
Grain Direction along 3.04	N/A					

Measured by:	IB
Date:	11-8-16

Audited by:	
Date:	11/08/16

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM	
B	07.09.06	Dimensions added	KJ/JLM	
C	08.01.16	Dimensions revised per Dwg Rev. C	KJ/EC/DD	